

FIG. 1

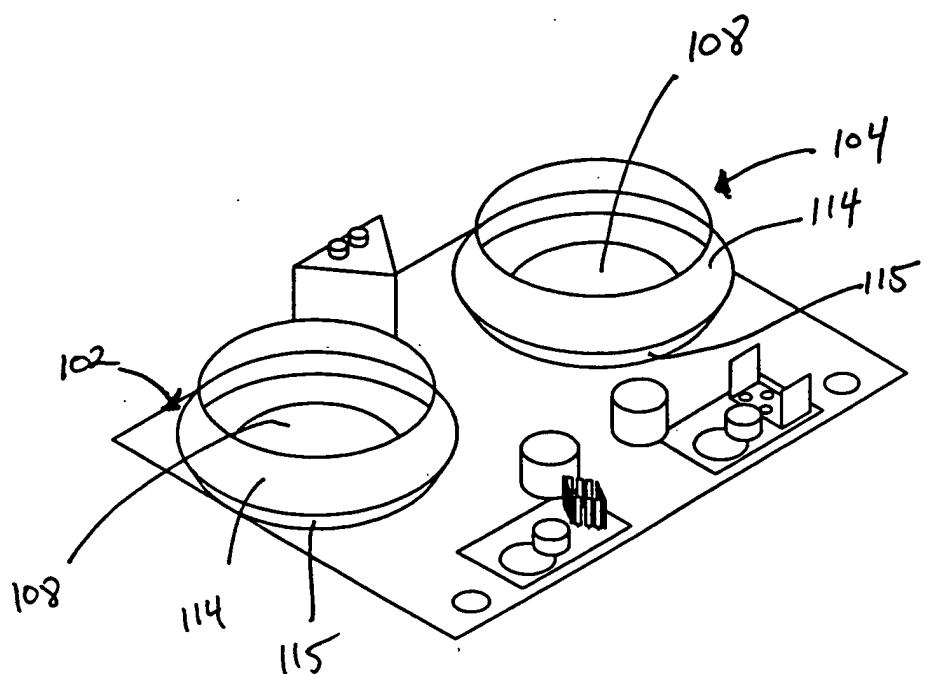


FIG. 2

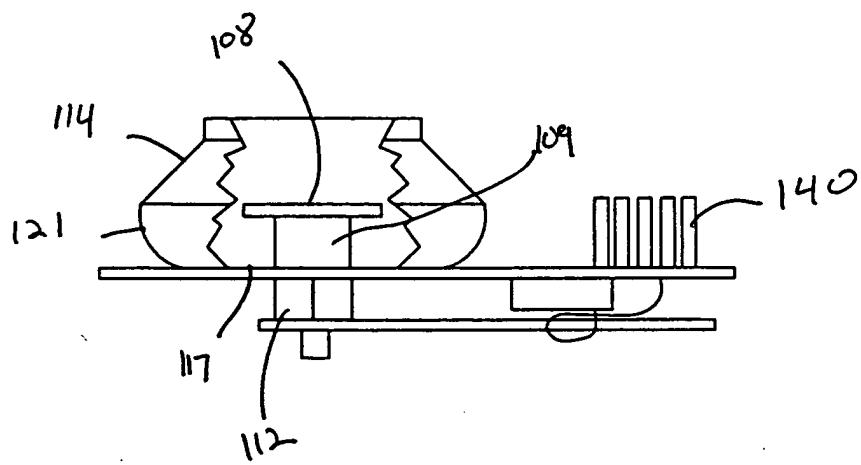
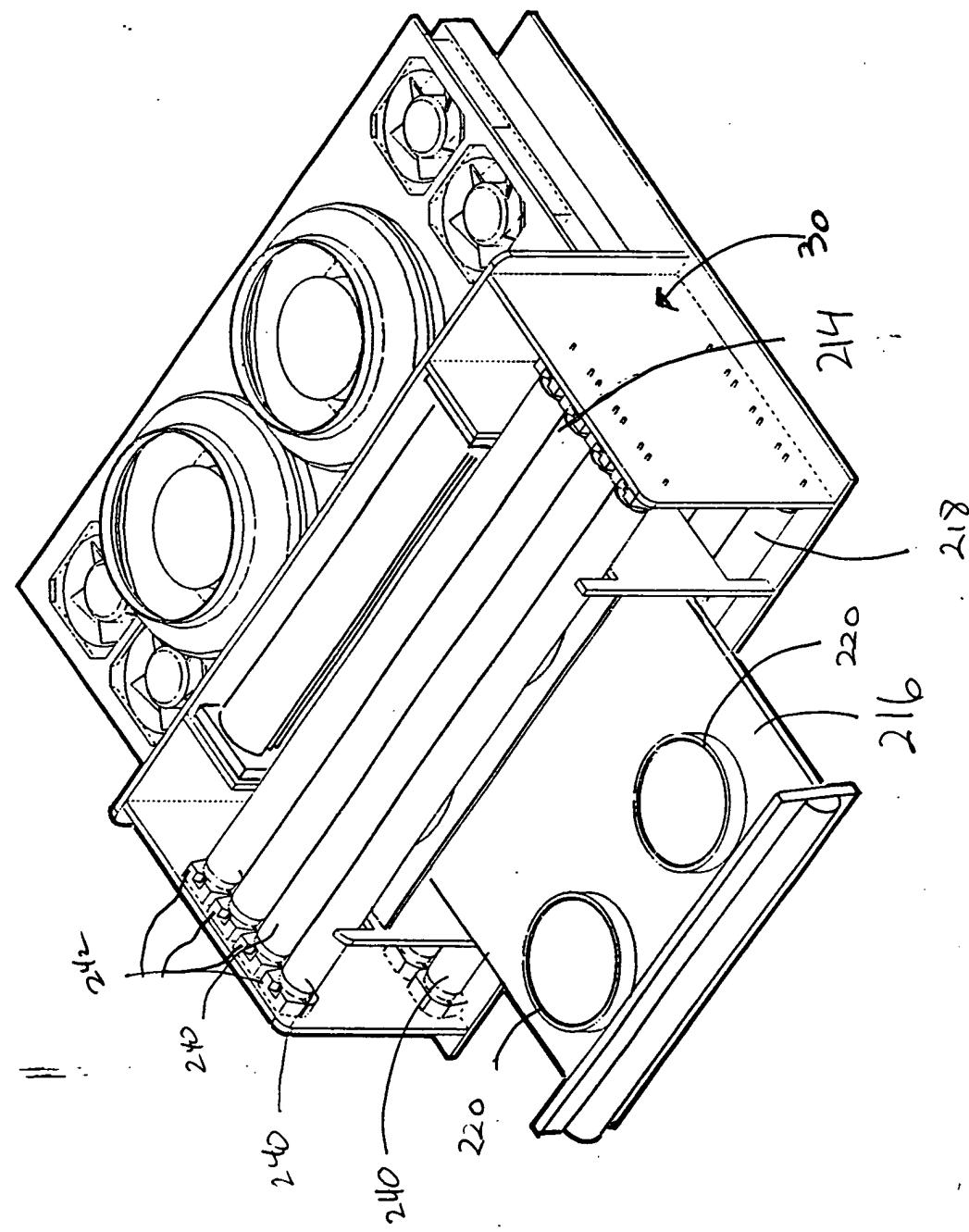


FIG. 3

FIG. 4



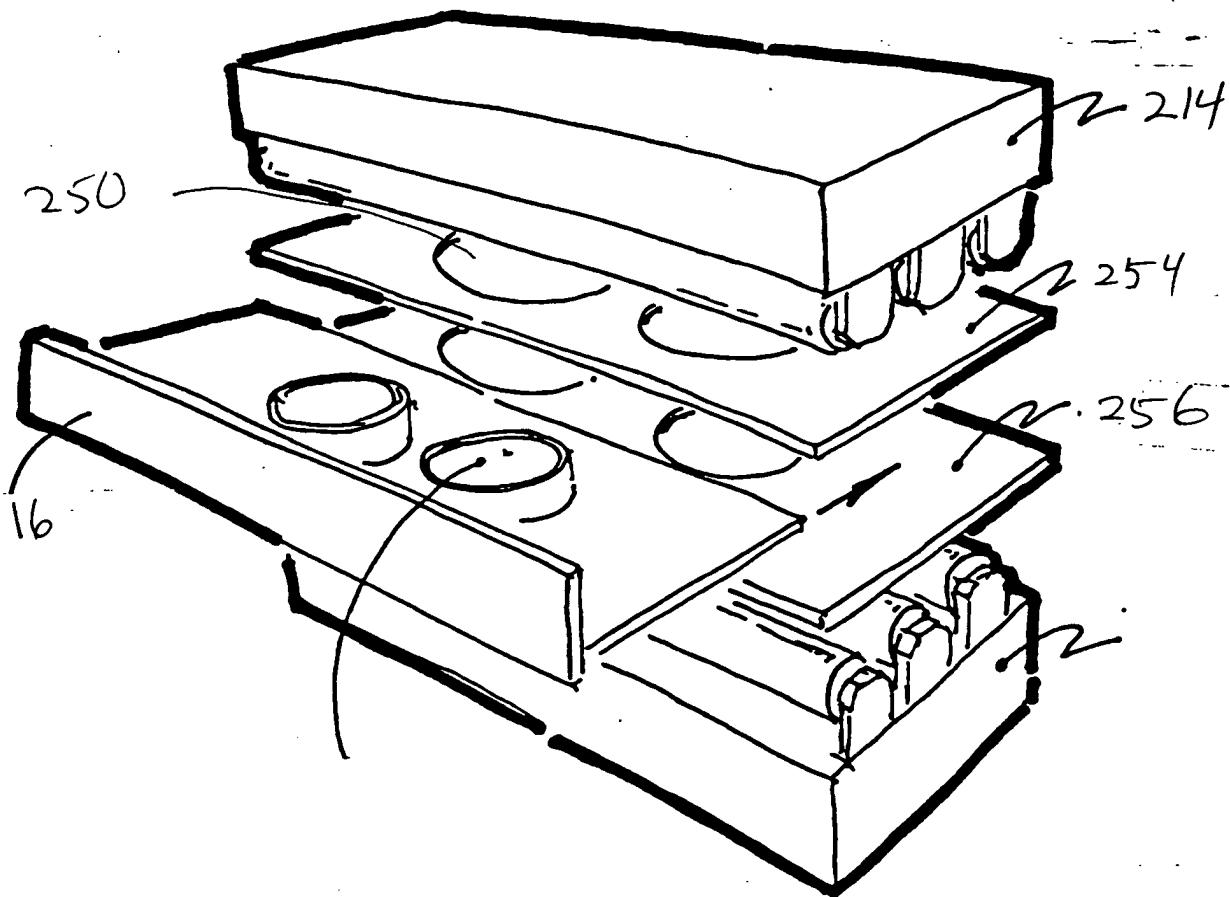


FIG. 5

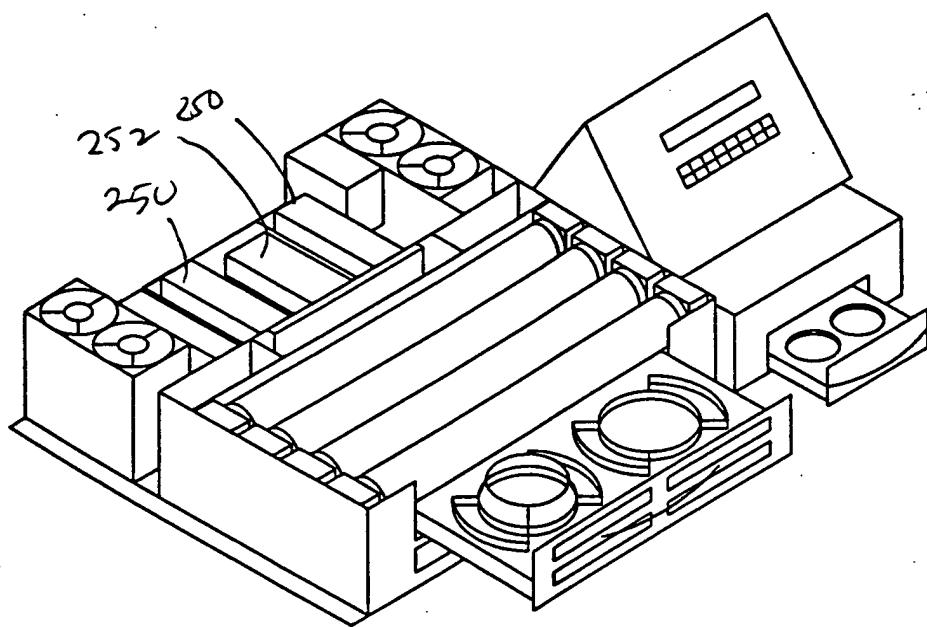
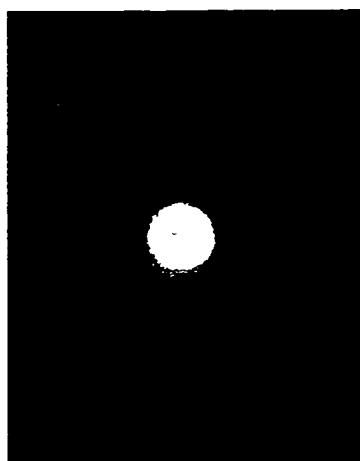
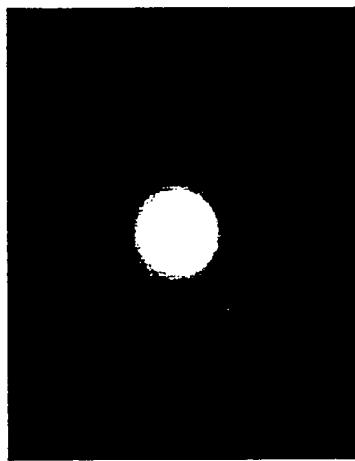


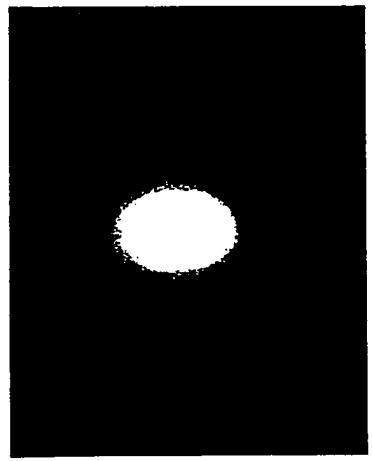
FIG. 6



A



B



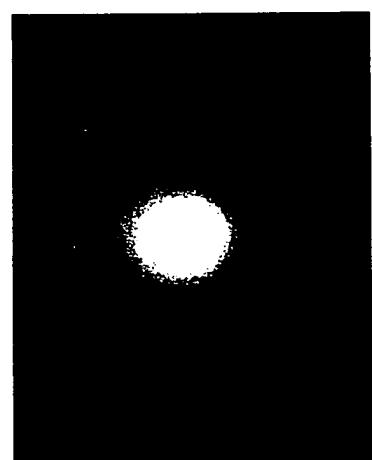
C



D



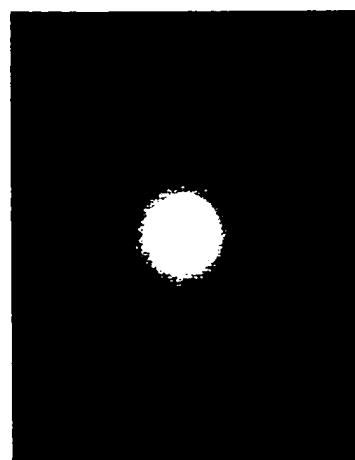
E



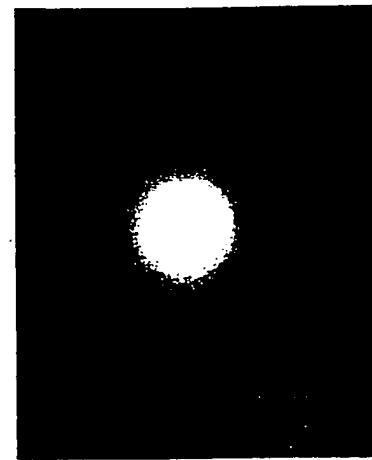
F



G



H



I

FIG. 7

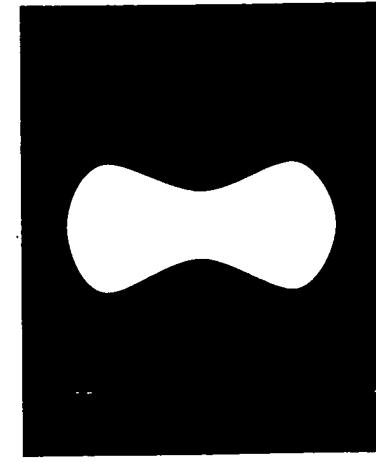
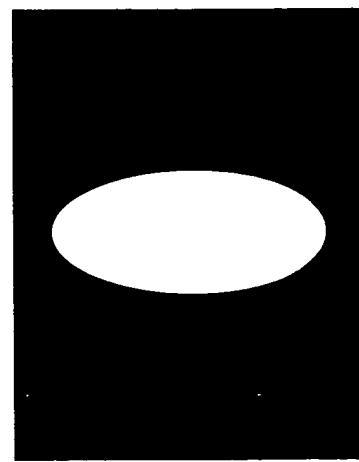
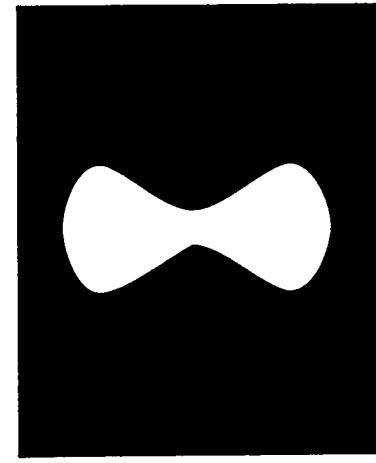
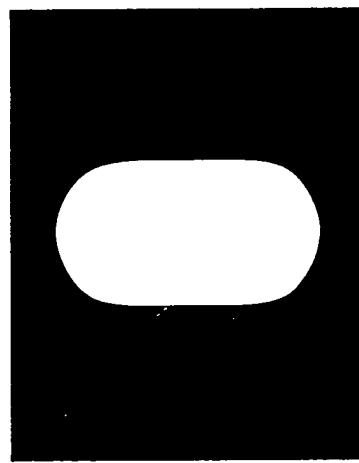
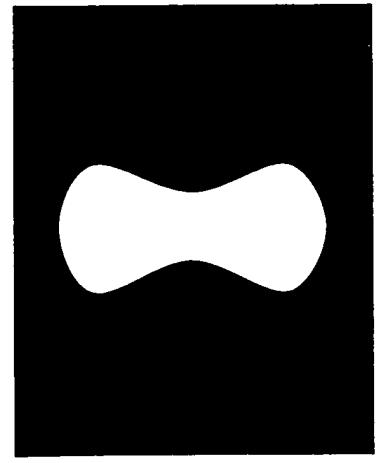
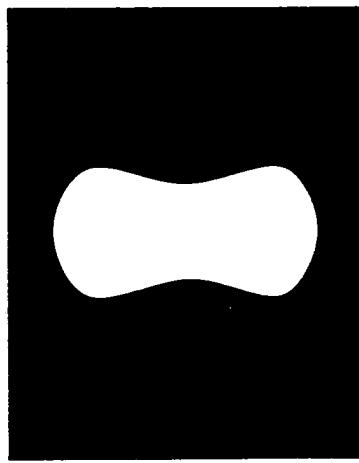
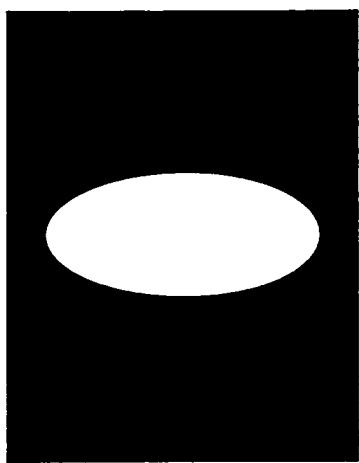
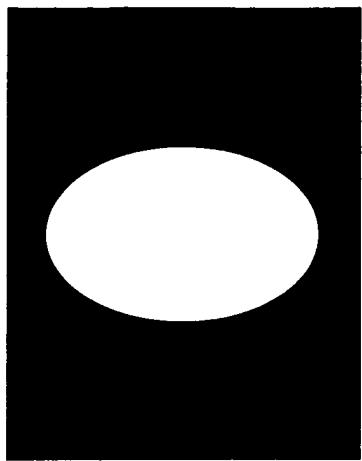
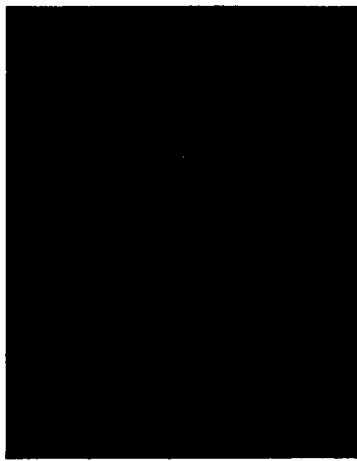


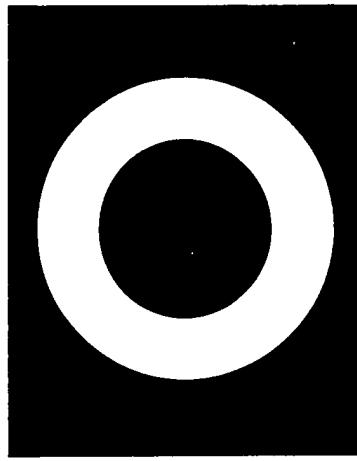
Fig. 8



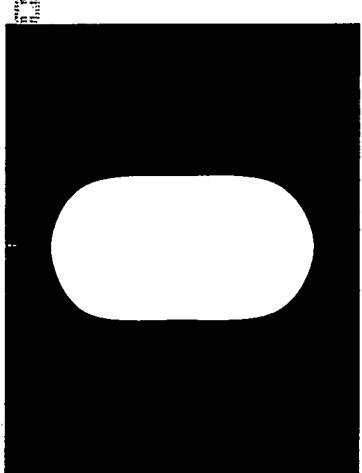
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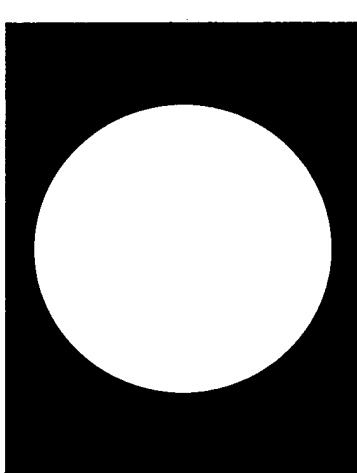
B



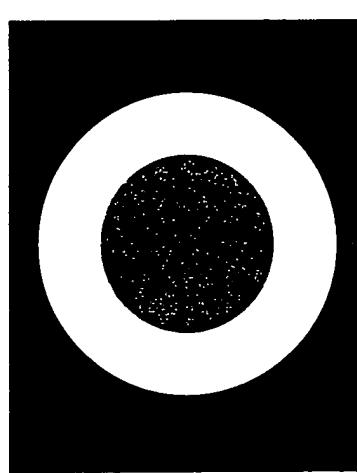
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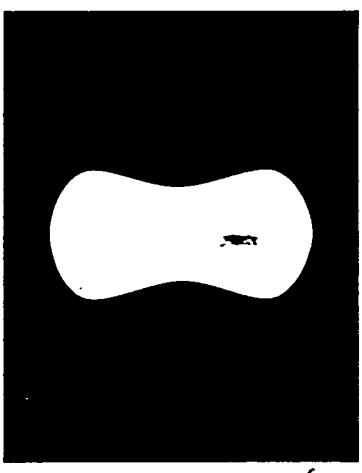
D



E



F



G

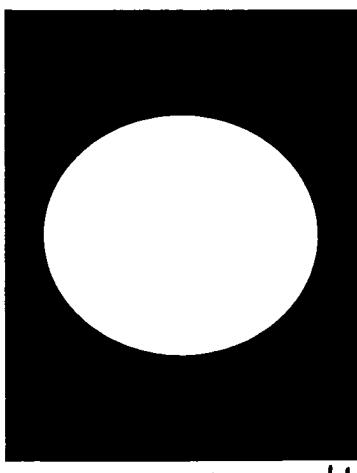
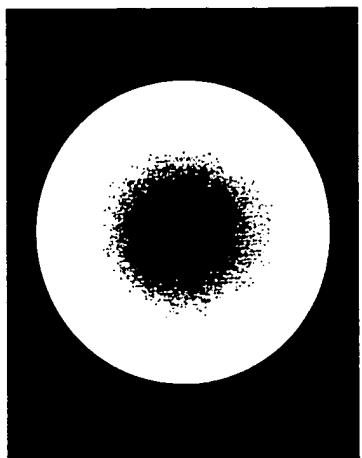


FIG. 9

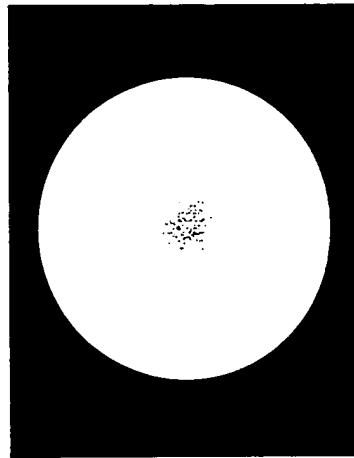
H



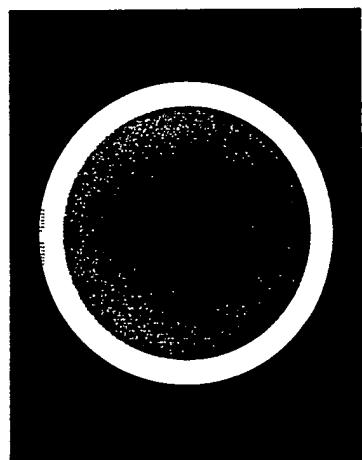
I



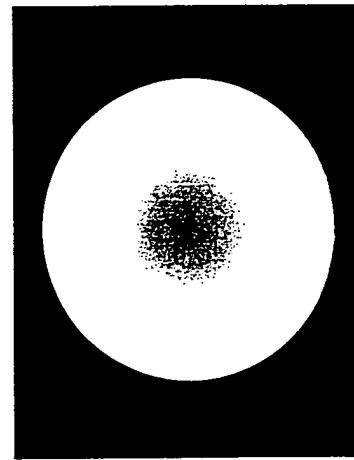
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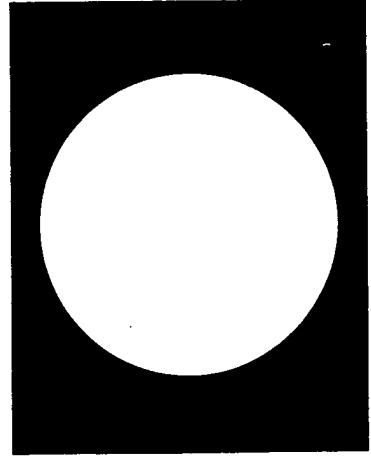
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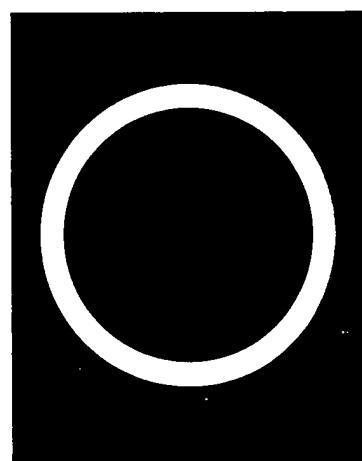
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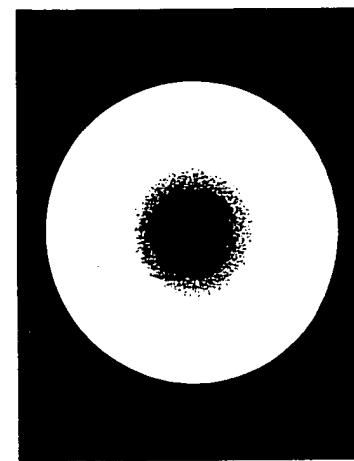
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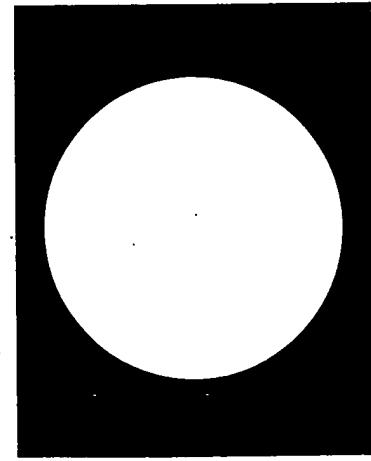
F



G



H



I

FIG. 10

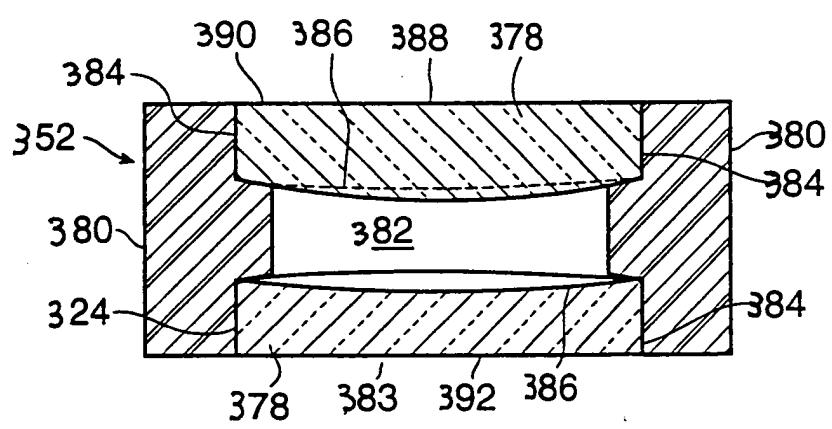


FIG. 11

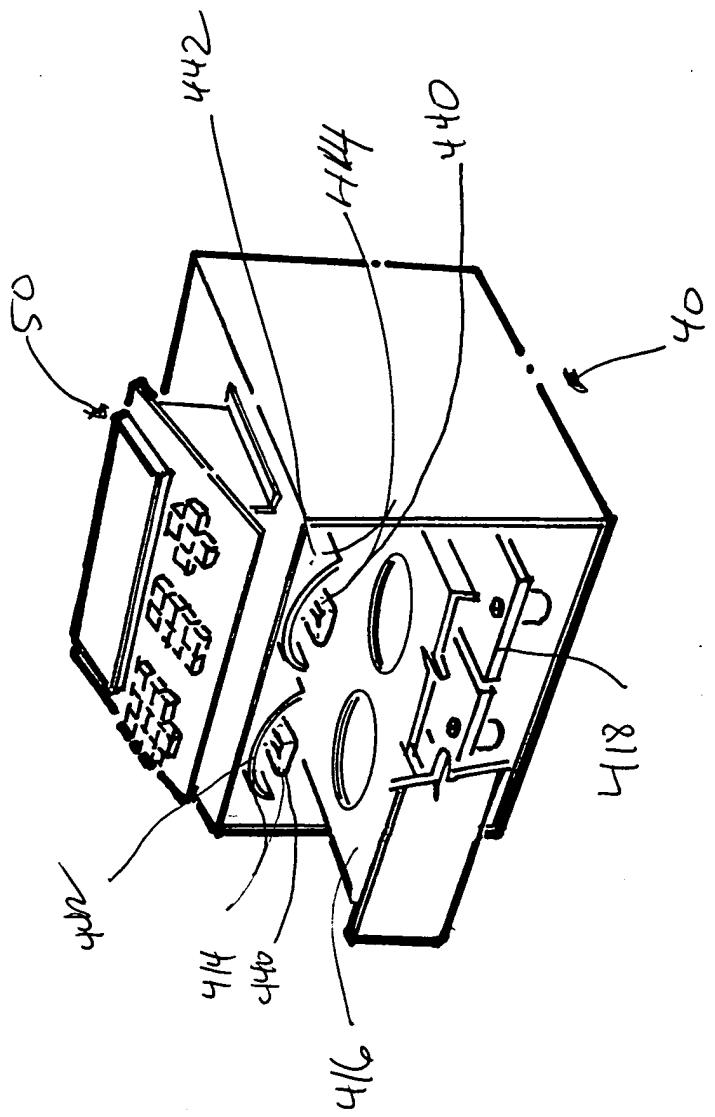
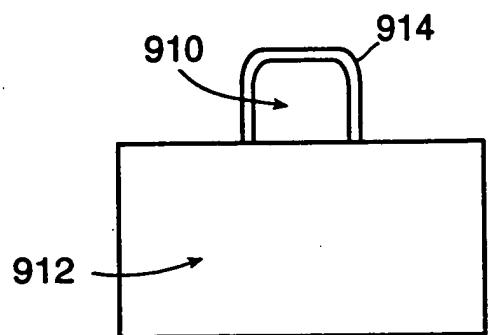
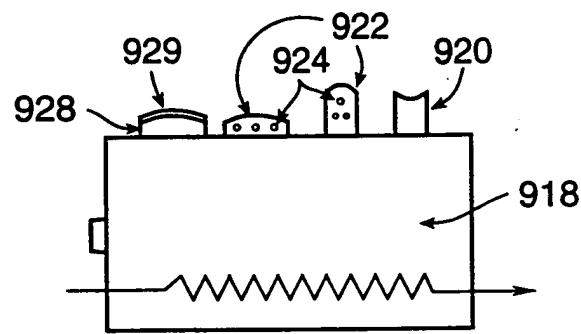


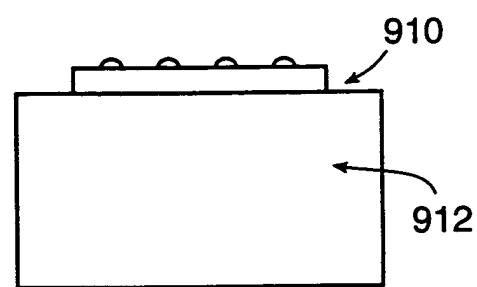
FIG. 12



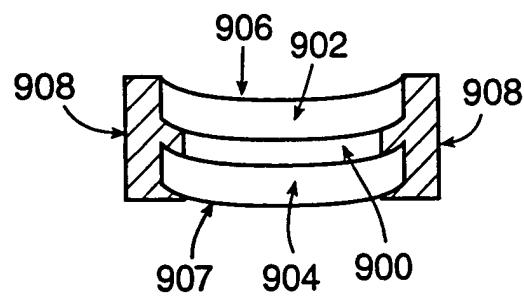
**FIG. 13**



**FIG. 14**

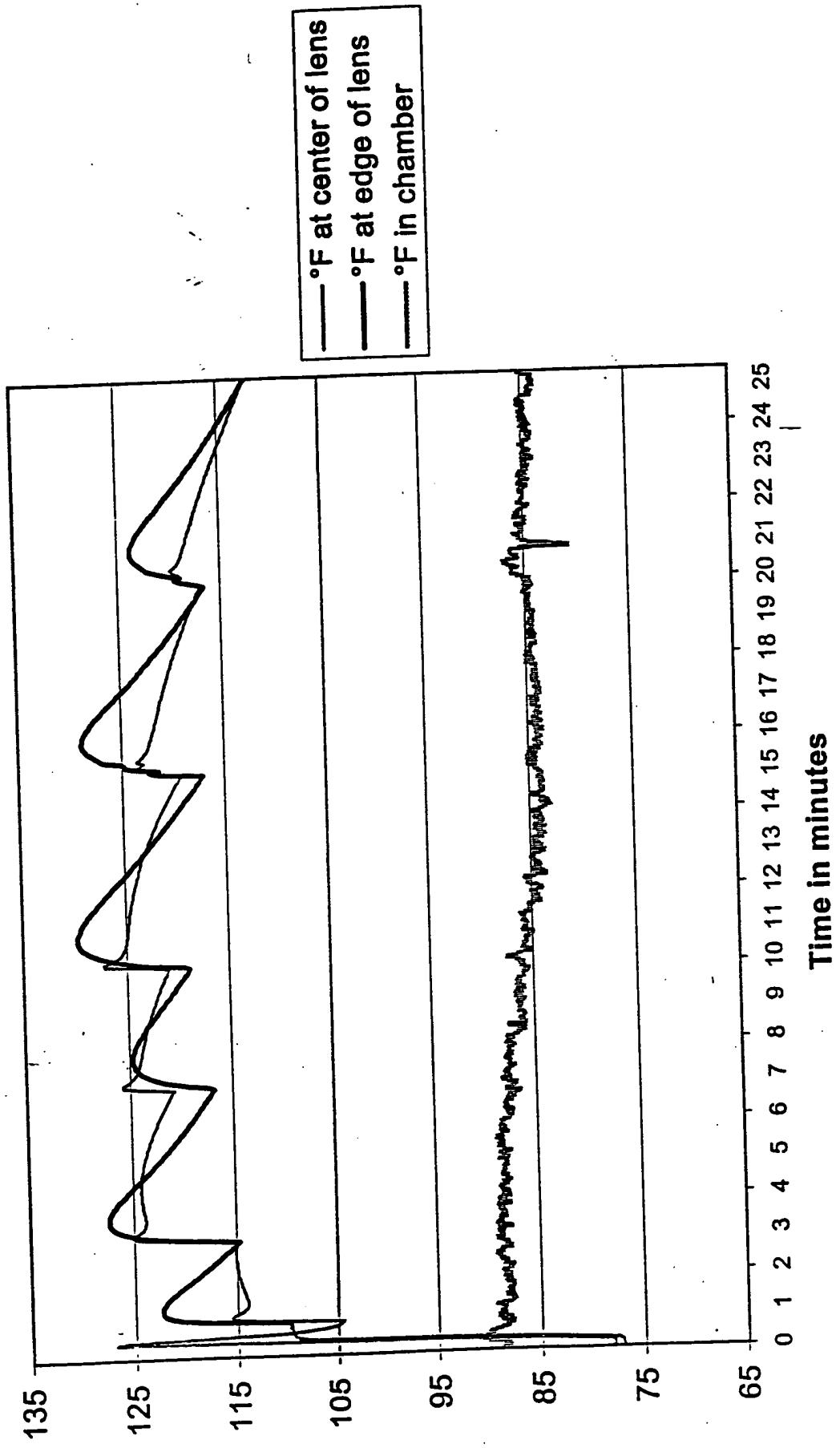


**FIG. 15**

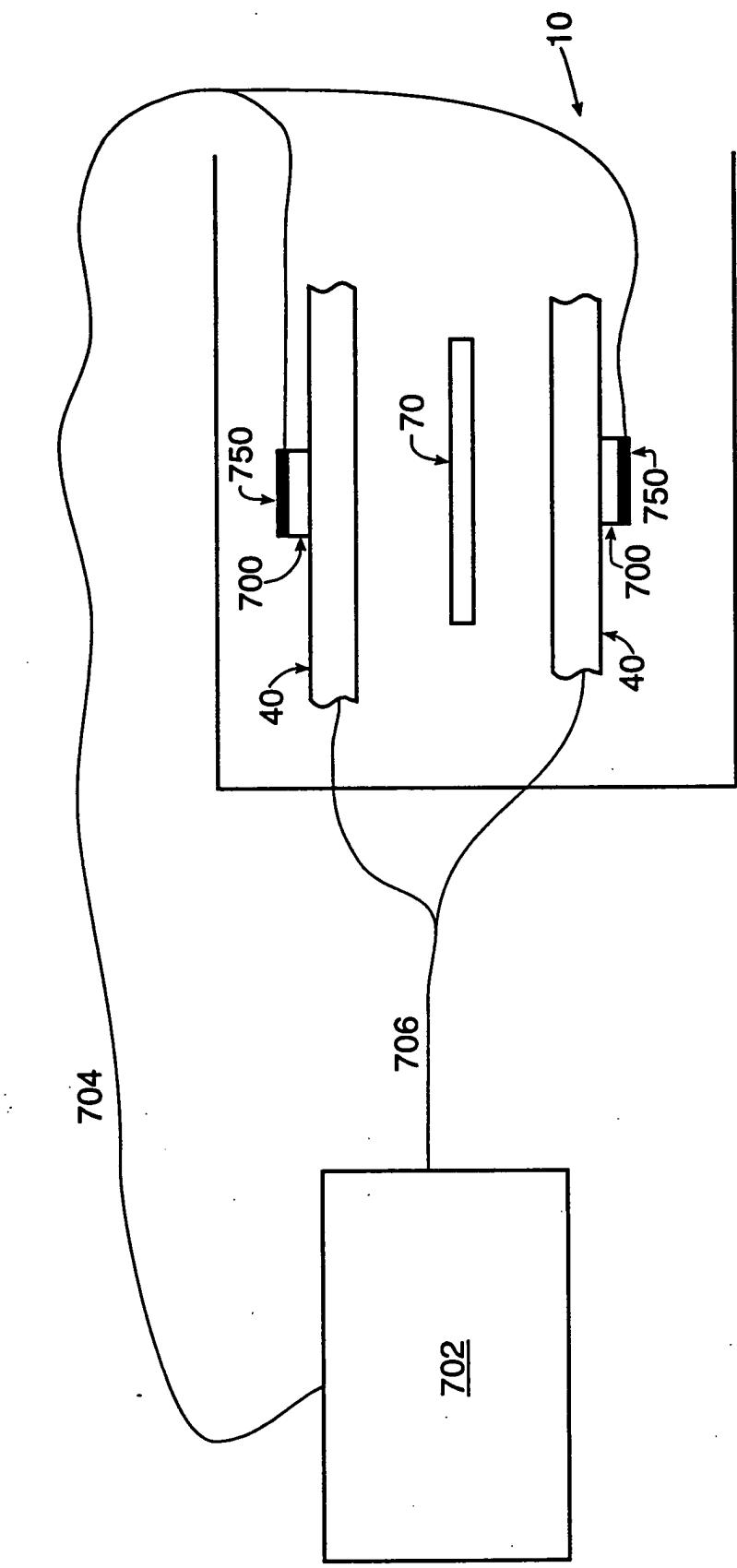


**FIG. 16**

Fig. 17



**FIG. 18**



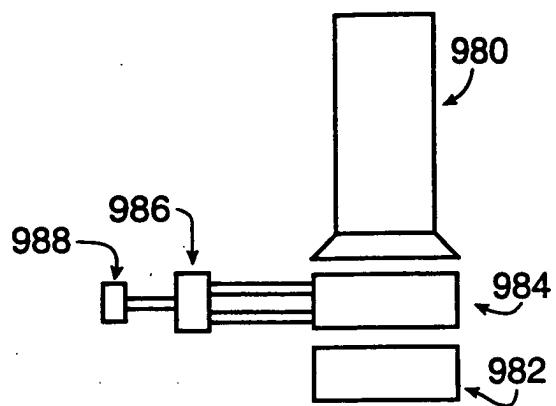


FIG. 19

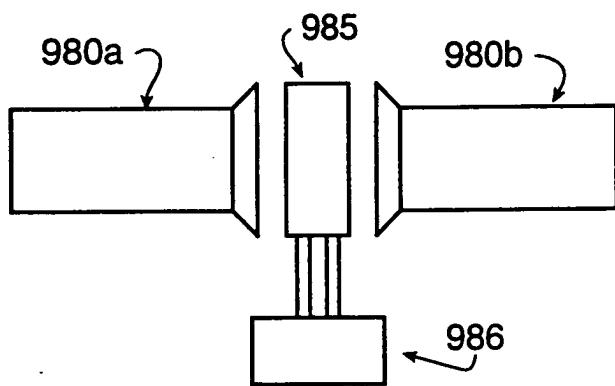


FIG. 20

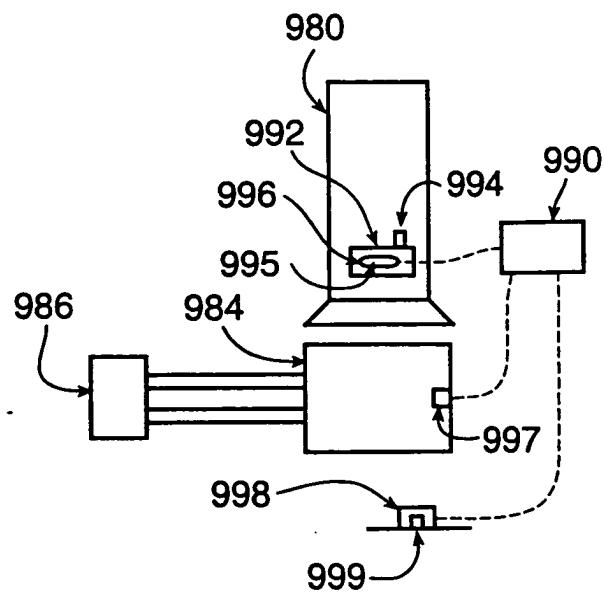


FIG. 21

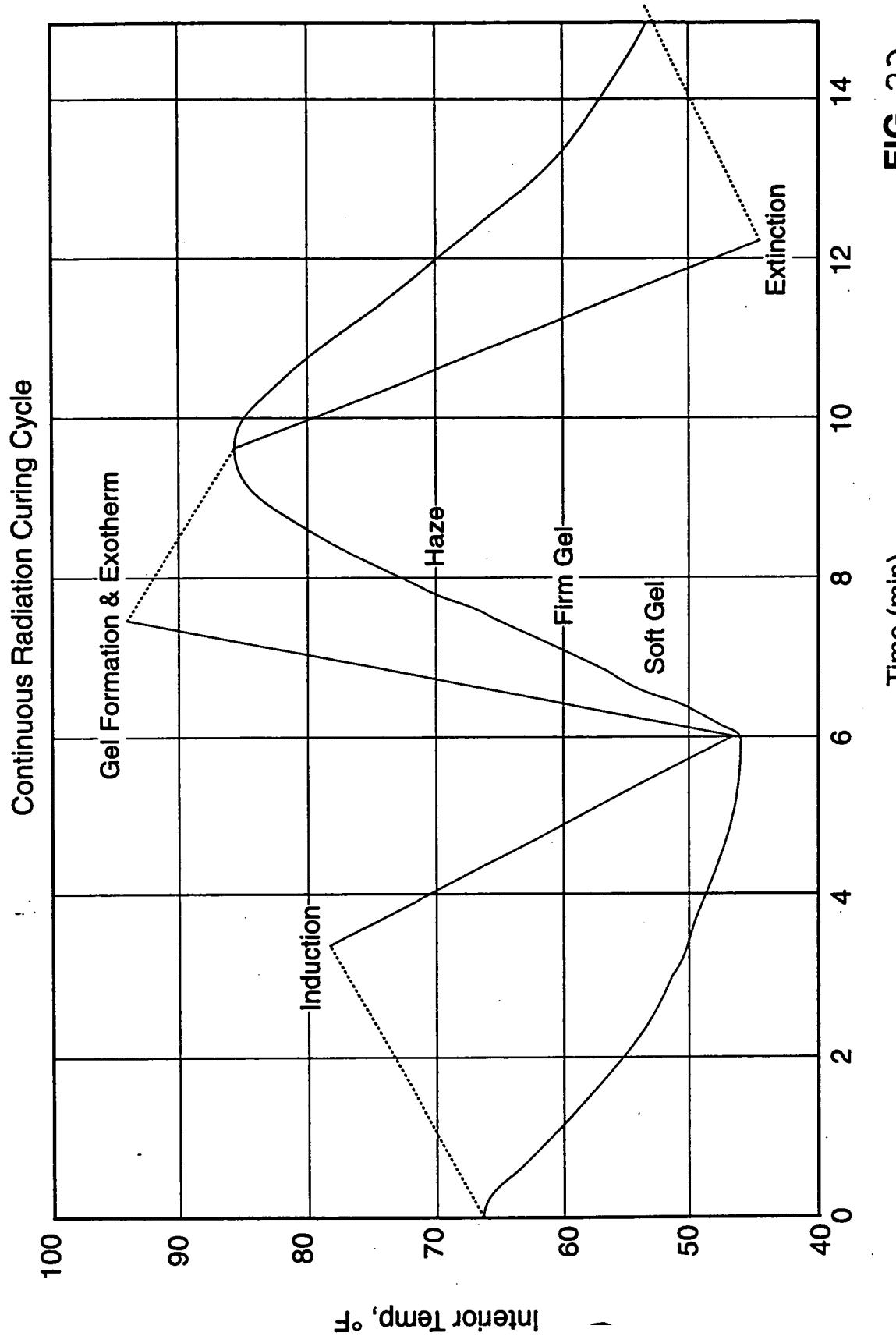


FIG. 22

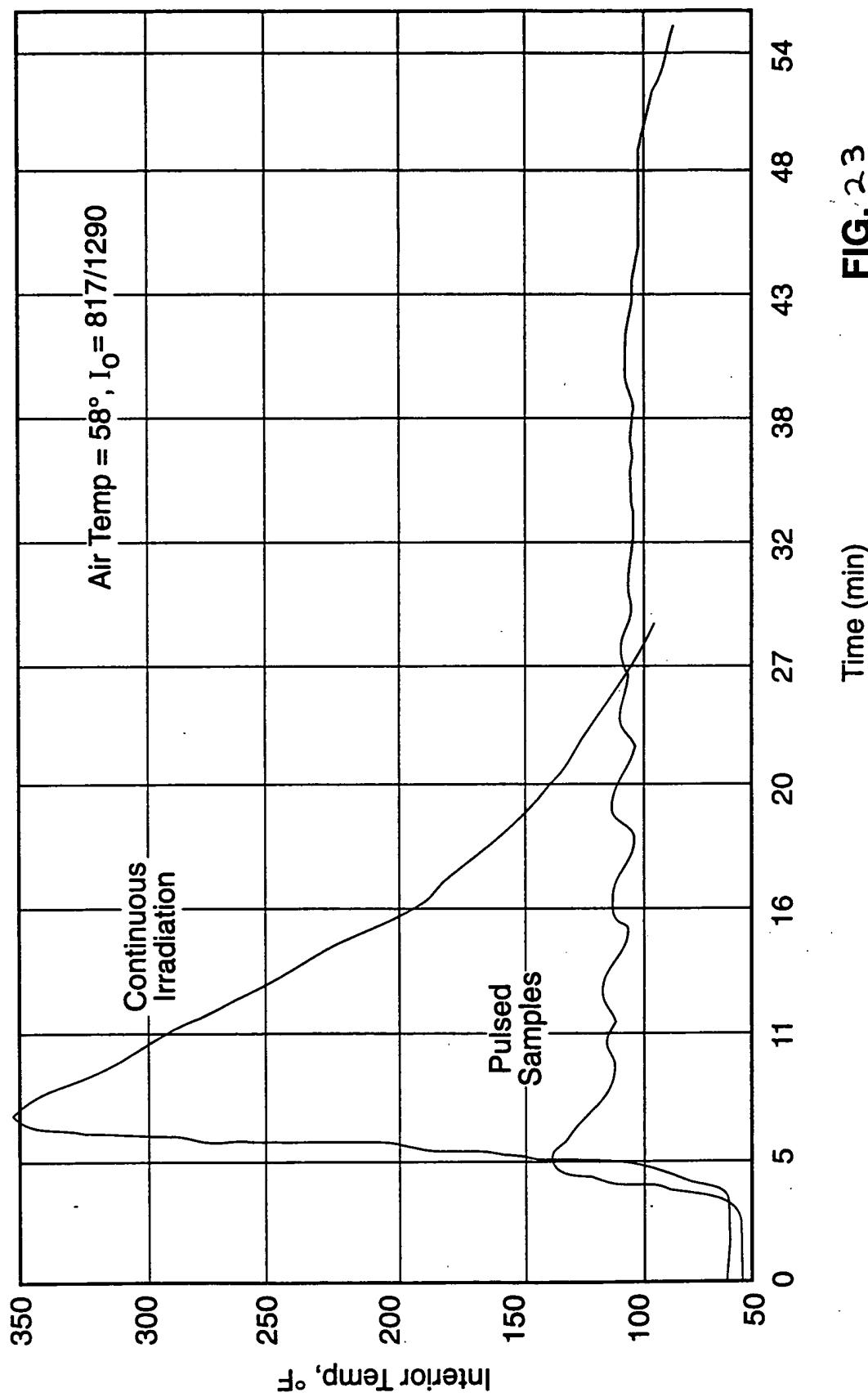


FIG. 23

**FIG. 2.4****Interaction of Pulsed Method Variables**

The effect that this variable will tend to have:  
**MASS OF SAMPLE**

On this cycle  
variable in:

**OPTIMAL  
INITIAL  
EXPOSURE  
TIME**

**LIGHT INTENSITY**

**RATE OF COOLING**

**IDENTITY OF MONOMER**

<b>TOTAL CYCLE TIME</b>	As sample mass increases, initial exposure time may be increased. The mass of the sample interacts with light intensity to determine a preferred initial exposure time.	As light intensity increases, initial exposure time may tend to decrease. The light intensity level may be controlled for a fixed curing cycle and initial exposure time. It is believed, however, that changes in light intensities may have little impact above a certain light "saturation" point for the sample.	Increased rates of heat removal may allow for a reduction in the time between pulses and thus total cycle time.	Increased rates of heat removal tend to allow for a reduction in the time between pulses.

**TIMING  
BETWEEN  
PULSES**

## Interaction of Pulsed Method Variables (continued)

The effect that this variable will tend to have:

MASS OF SAMPLE	LIGHT INTENSITY	RATE OF COOLING	IDENTITY OF MONOMER
In this cycle variable in:  TOTAL EXPOSURE TIME	Increased sample mass tends to require both increased initial exposure time and a greater number of pulse/cooling cycles.	Increased light intensity will tend to result in decreased total exposure time and decreased light intensity will tend to require increased exposure time. It is believed, however, that changes in light intensities may have little impact above a certain light "saturation" point for the sample.	A significant effect that monomer identity may have on total cycle time may be contributed by differences in the preferred initial exposure period. Various lens forming materials may also require longer/shorter duration pulses depending upon their reactivity.
DURATION OF PULSES	The length of the pulses during each phase of the curing cycle may be adjusted for different mass samples. The time between pulses may be increased /decreased according to mass.	The duration of the pulses may be varied in inverse proportion with the light intensity selected. It is believed, however that changes in light intensities may have little impact above a certain light "saturation" point for the sample.	Various lens forming materials require different pulse duration depending upon their reactivity. For a selected material, slight differences in initiator & inhibitor levels will not tend to affect pulse duration.

**FIG. 24**  
(continued)

FIG. 25

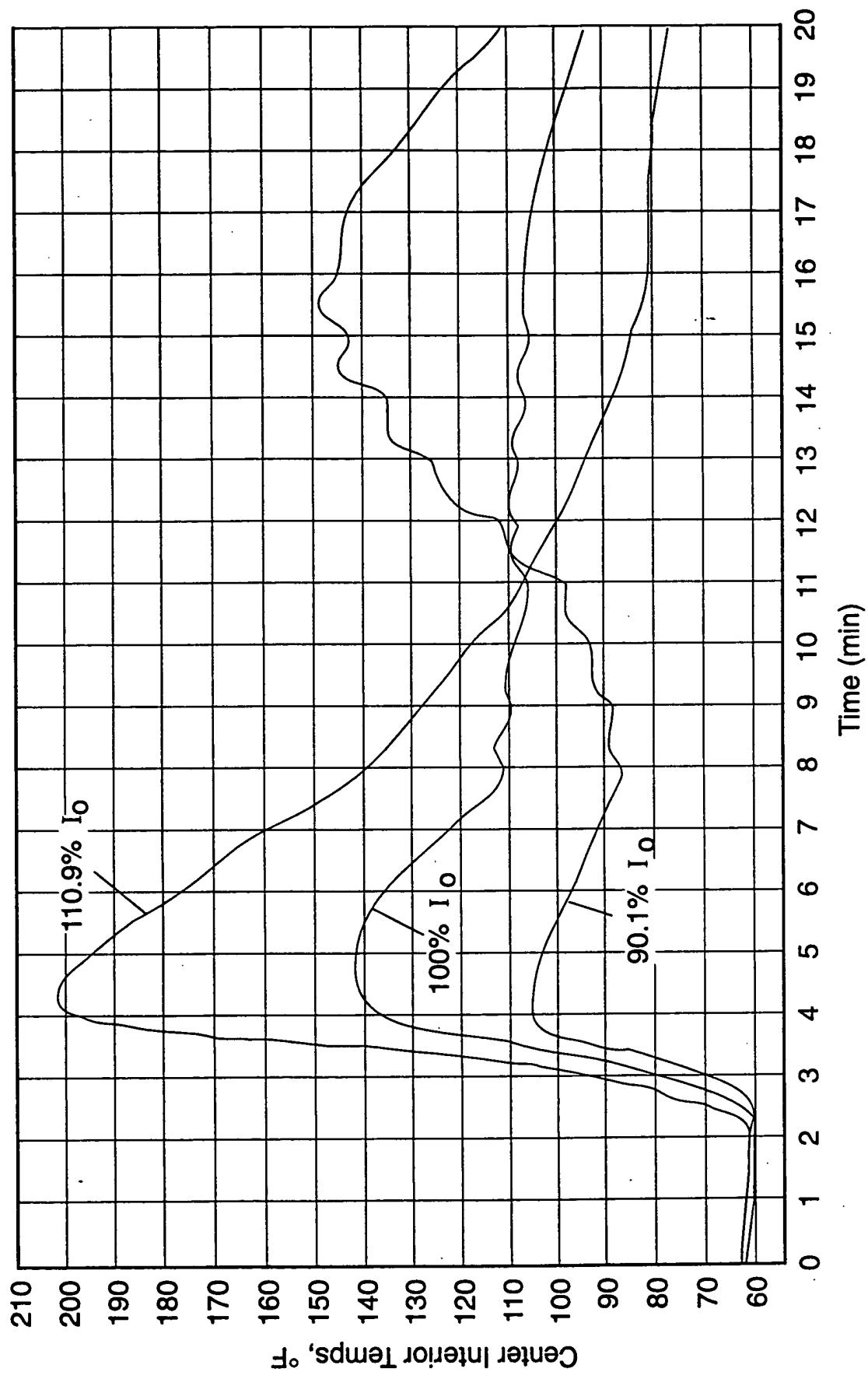
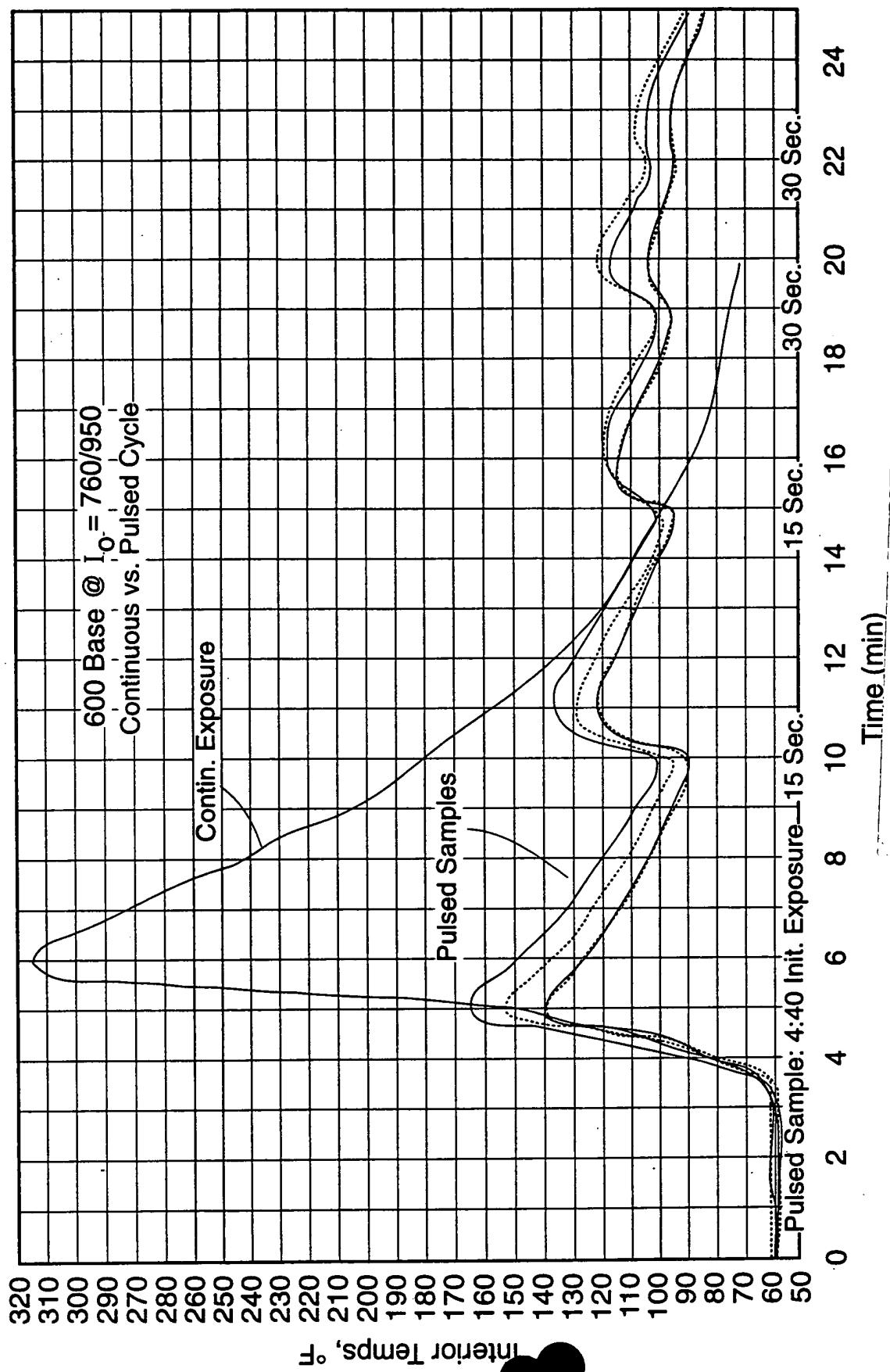


FIG. 26



**FIG. 27**

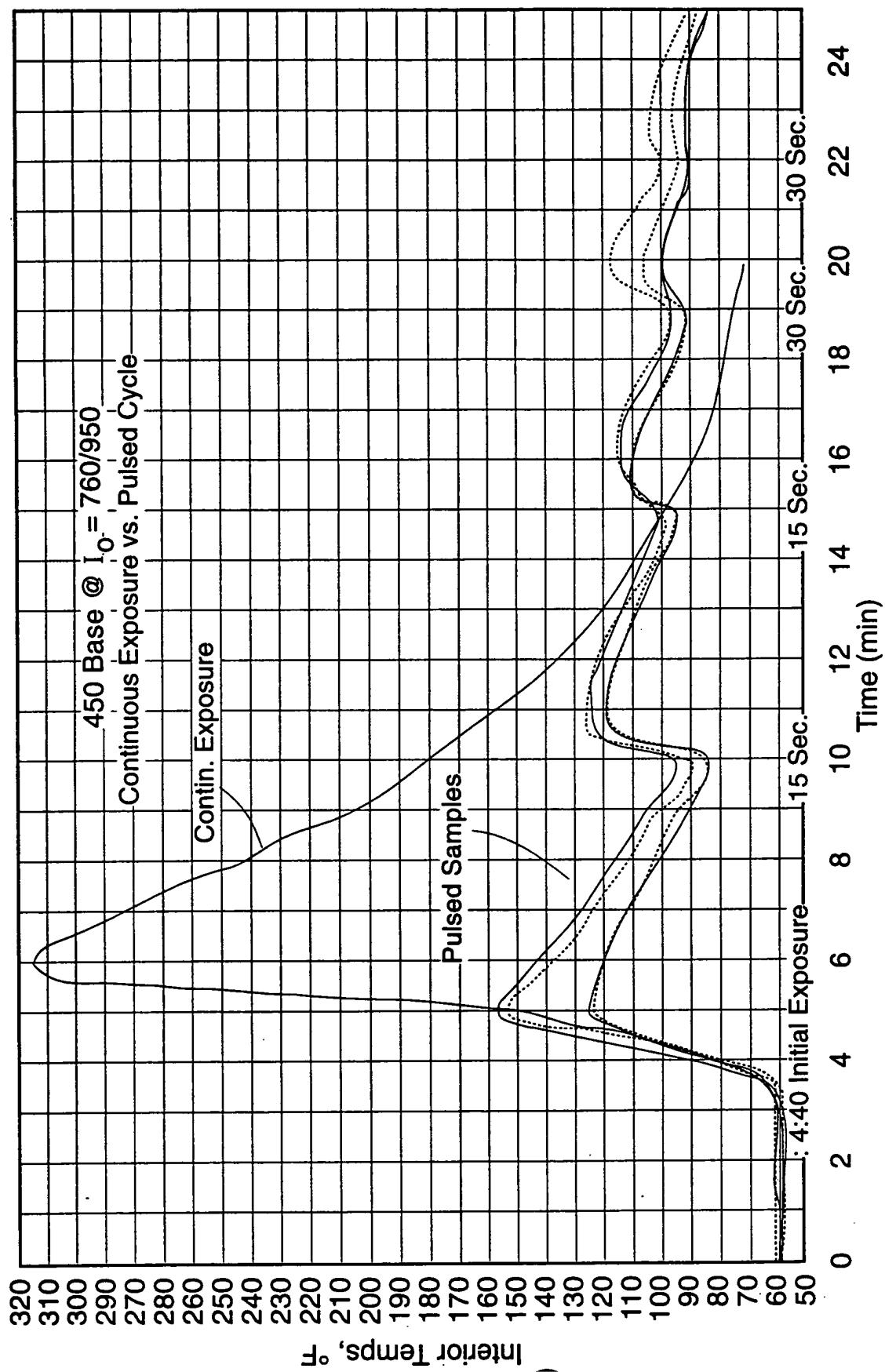
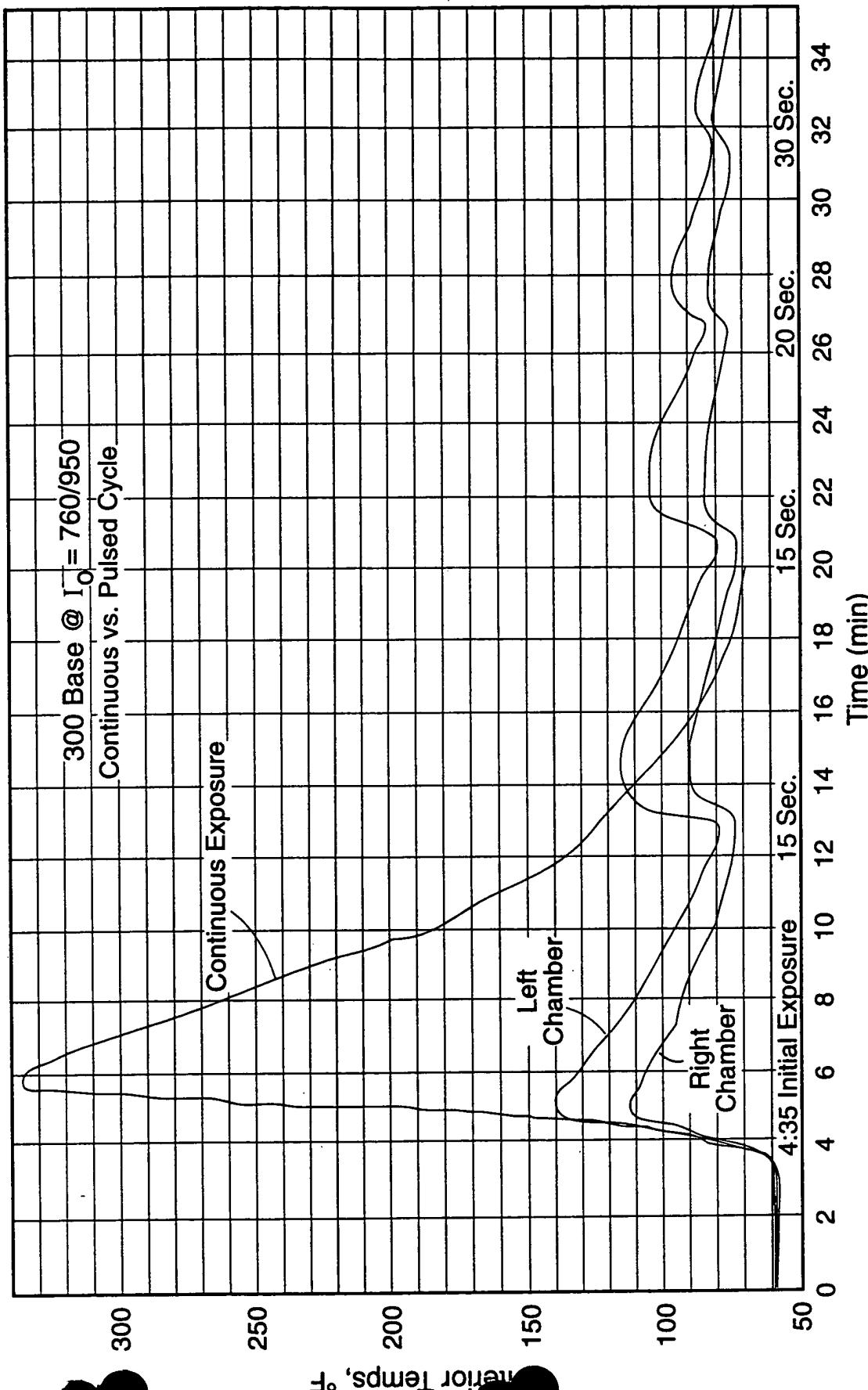


FIG. 28



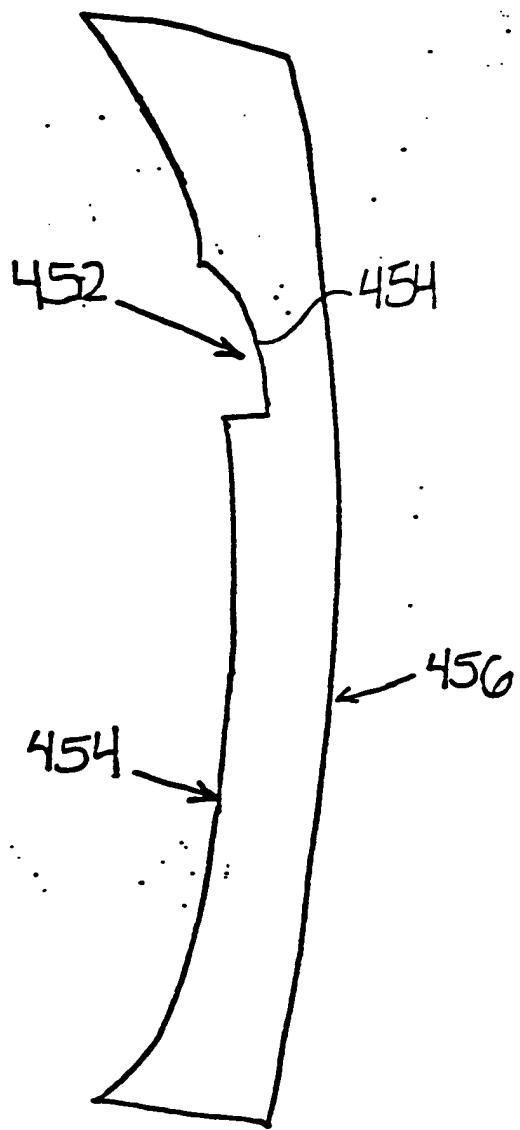


FIG. 29

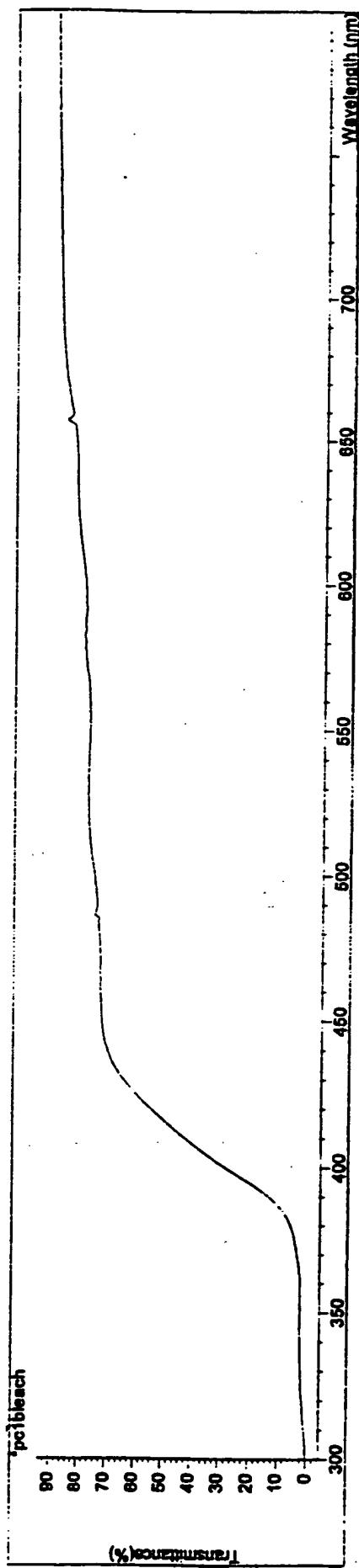


FIG. 30

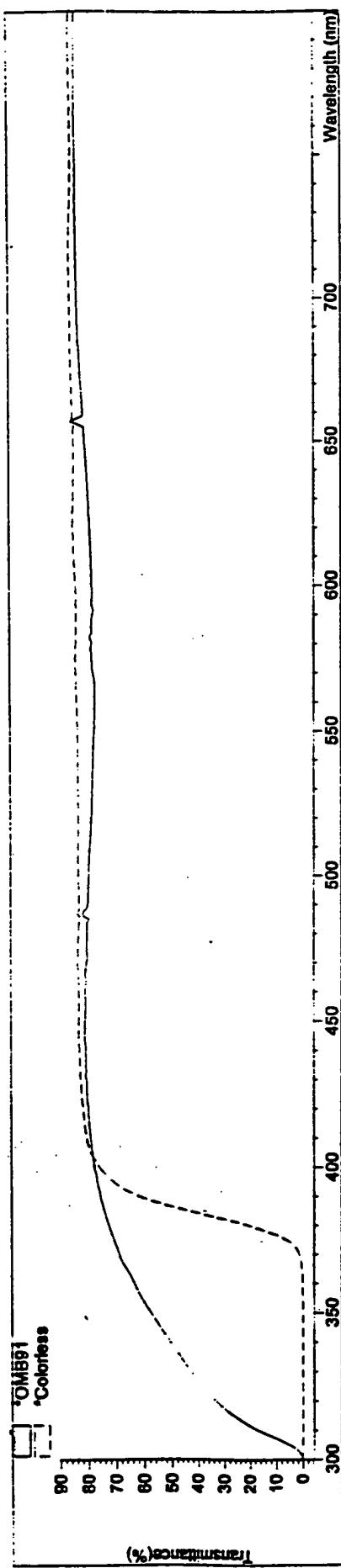


FIG. 31

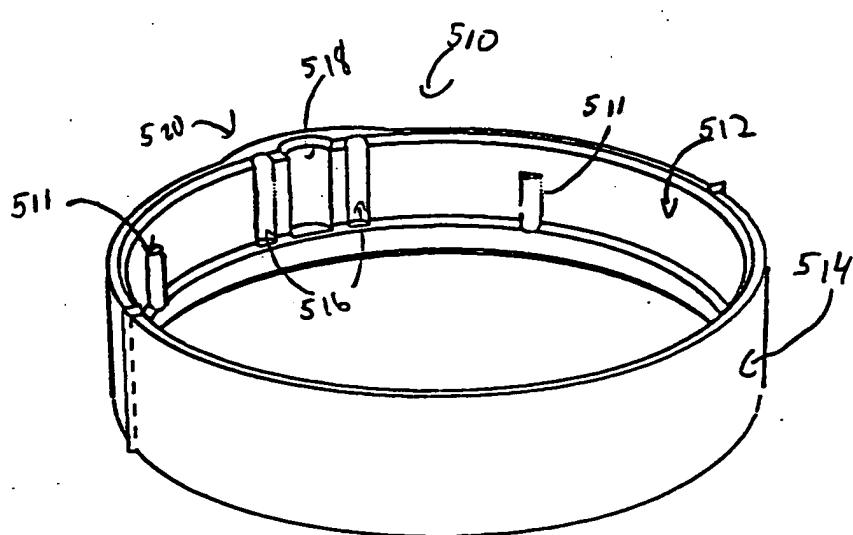


Fig. 32

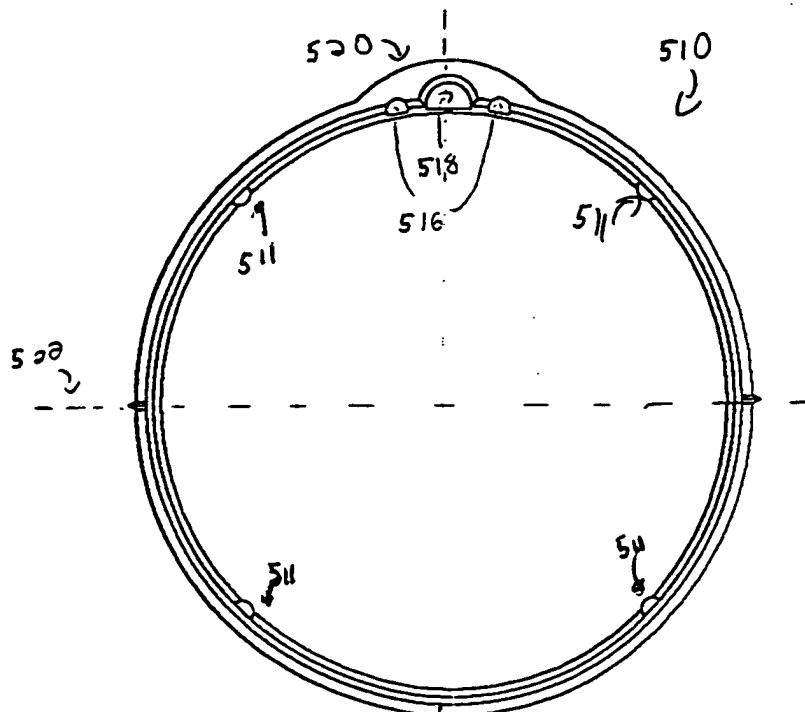


Fig. 33

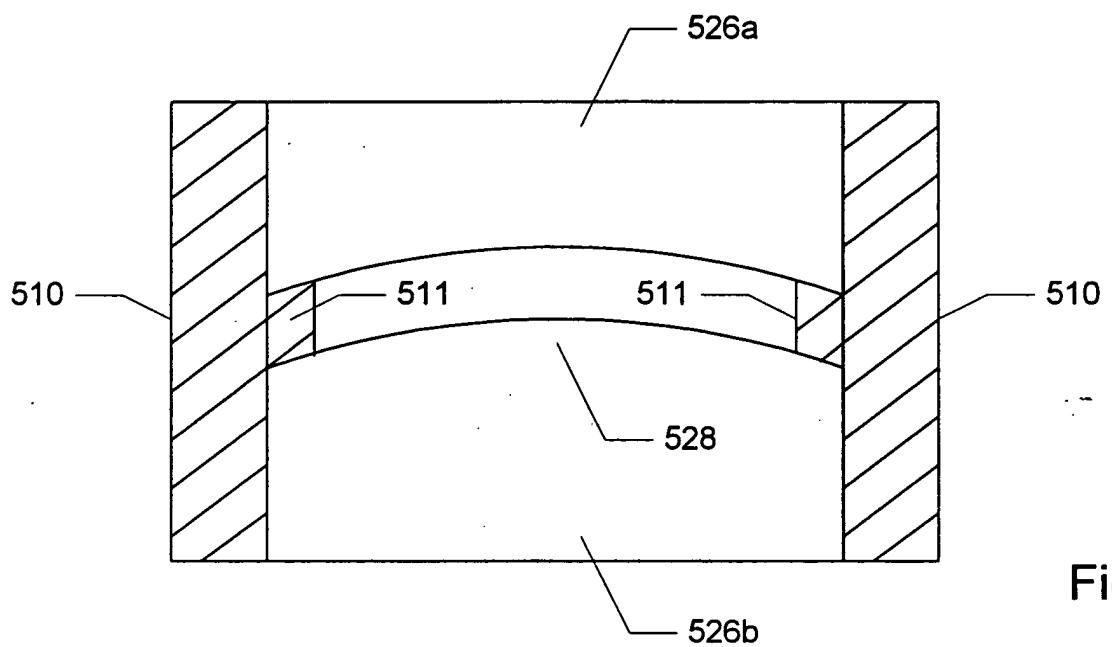


Fig. 34

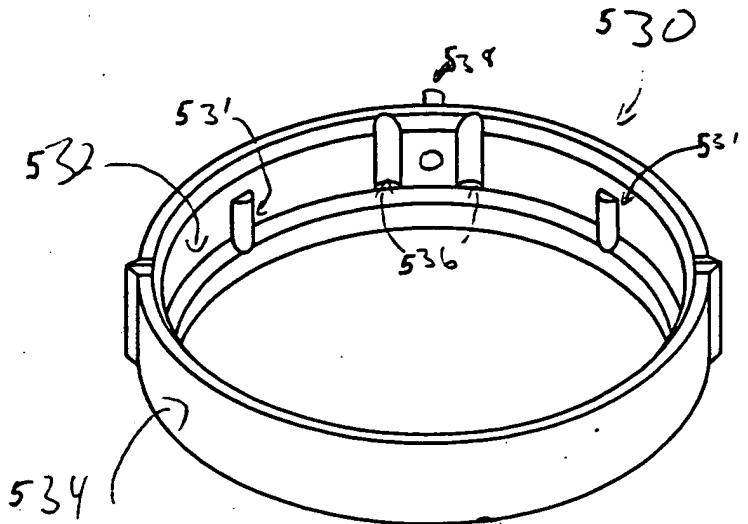


Fig. 35

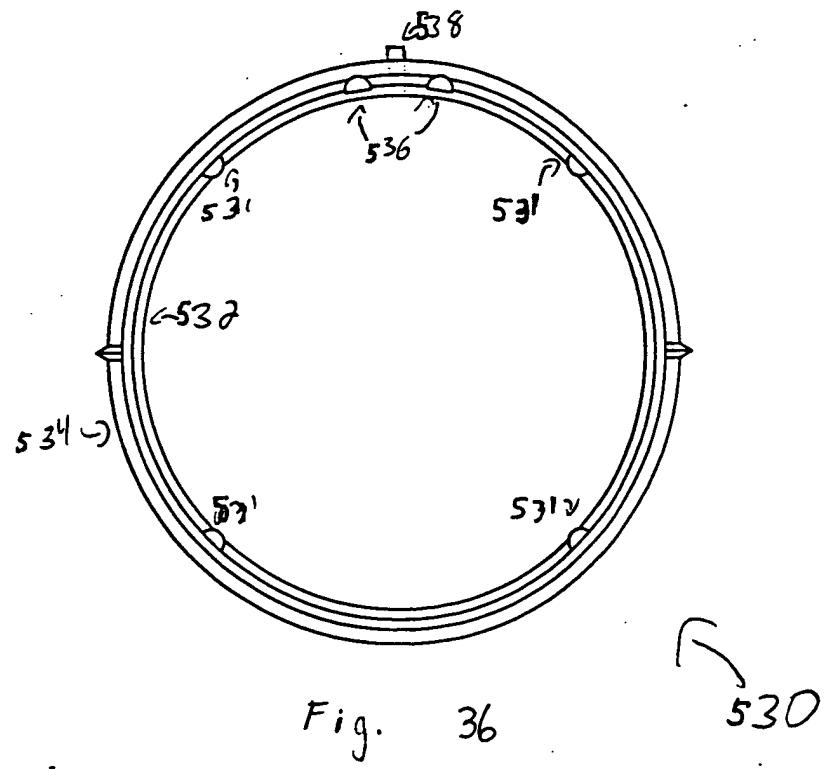
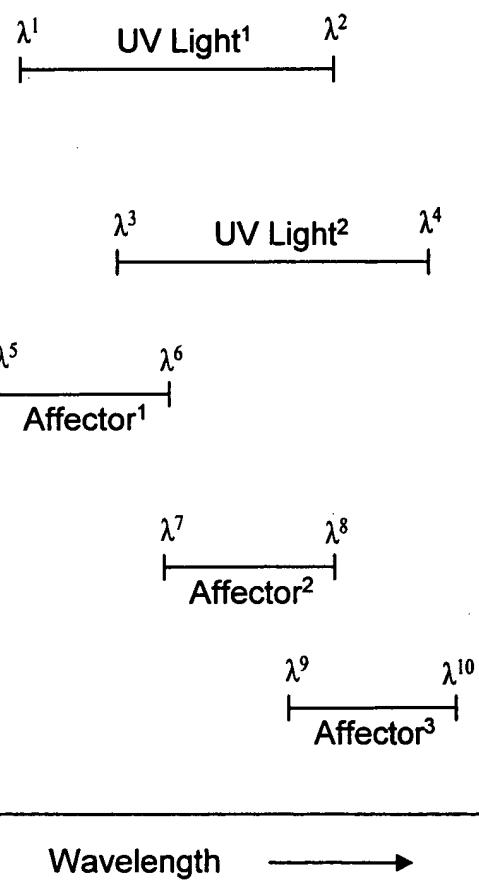


Fig. 36



**FIG. 37**

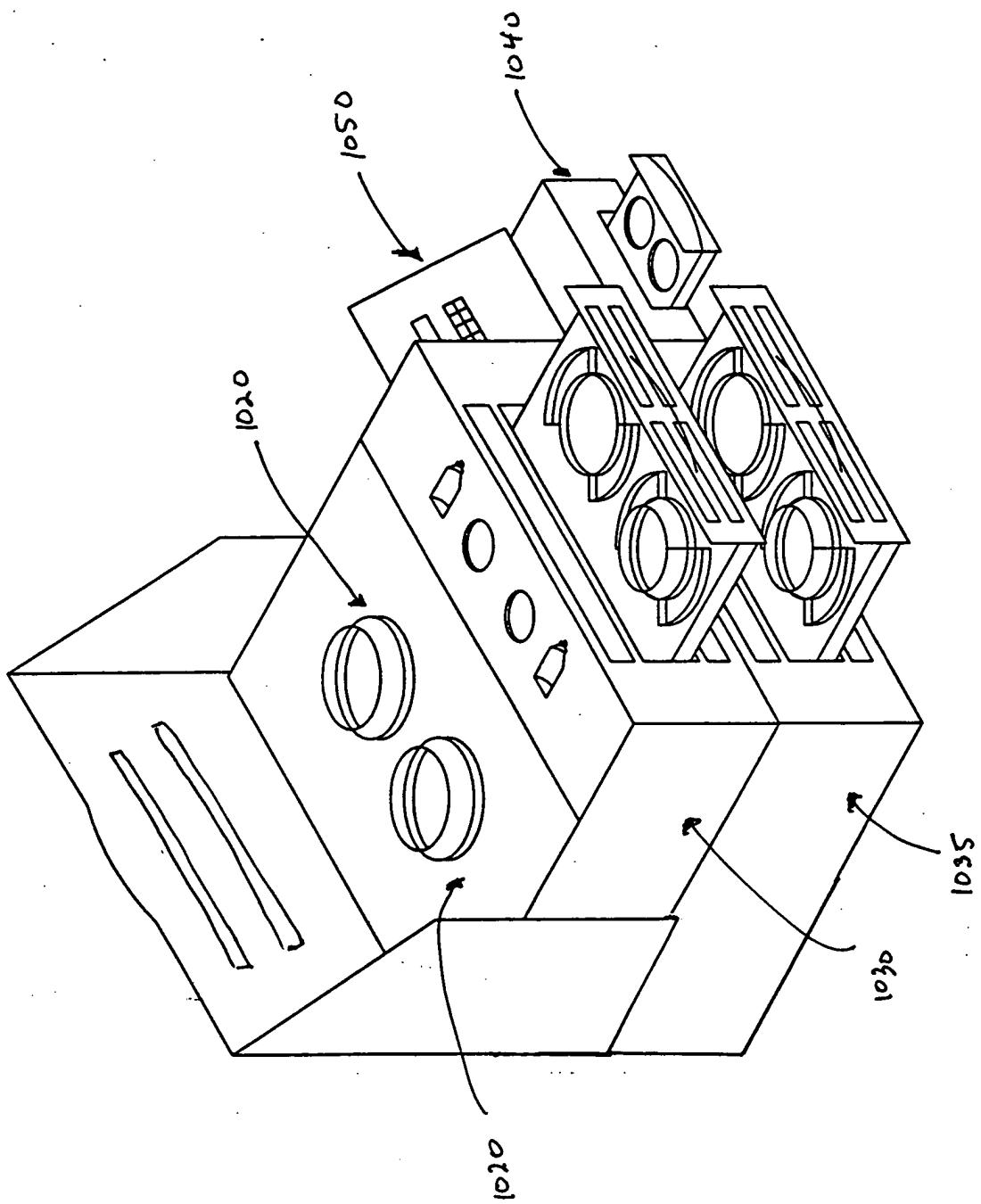


FIG. 38

